

Work Order ID 71974

Thursday, July 14, 2011 1:13:46 PM



Page 1

Item ID: D3556-1

Accept



Setup Start



Revision ID:

Item Name: Clamp

Stop



Start Date: 7/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: C2 Date: 11/07/14 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3556 | Rev B |

P10 →

100 PURCHASING ? 0.00



Waterjet

Memo

0.00

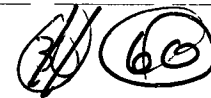
FLOW CNC Waterjet

1-Cut as per dwg D3556

prog rev: B
dwg rev: B

2-Deburr

B11-8-4



110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Memo

0.00

Quality Control

B11-8-4

| W/O: 71974 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3556-1 PAR #: N/A Fault Category: Small Job NCR: Yes ☒ No ☐ DQA: 18 Date: 11.09.08
 11-822 Resolution: acceptable Disposition: use as is QA: N/C Closed: OK Date: 11/09/08

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|-----------------------------|--|---------------------------|---------------------------|---------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11.08.08 | 110 | Slots are 0.360 instead of 0.375 on half of batch, Rec Program error MACHINE MALFUNCTION LOA | CP 11.05.08 QSI 042 | Acceptable. Clamps are flexible and fit will not be overly affected | n/a 11.05.08 Woolly | CP 11.05.08 QSI 042 | CP 11.05.08 QSI 042 | Woolly |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 71974

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Item ID: D3556-1

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Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 7/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

S wlosly

counted

660



QC

Memo

0.00

Quality Control

130

Small Fab

0.00

SB 11609102

59

60

60

PTO



Small Fab

Memo

0.00

Small Fab

1- Bend as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00

Sulor/02

count

59



QC

Memo

0.00

Quality Control

| W/O: 71974 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D35861 PAR #: V/A Fault Category: Small FAB water for NCR: Yes No DQA: 11 Date: 11-09-07
11-821 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/09/08 Date: 11/09/08

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) 10.48 | | | | | | |
|----------|------|---|---|---------------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11/09/07 | 150 | Found 1 part with hole on it R.C. to contact m/factory | <u>S</u> <u>11/09/07</u> <u>at 7:00pm</u> | Scrap - destroy | <u>S</u> <u>11/09/07</u> | <u>S</u> <u>11/09/07</u> | <u>S</u> <u>11/09/07</u> | <u>S</u> <u>11/09/07</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 71974

Thursday, July 14, 2011 1:13:46 PM



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Item ID: D3556-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 7/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 459

0.00



Packaging

Memo

0.00

Packaging

11/9/25

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/18MP

Picklist Print

Thursday, July 14, 2011 1:13:43 PM

Page 1

Work Order ID: 71974



Parent Item: D3556-1



Parent Item Name: Clamp



Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-23 JLM
IPP Rev:B 08-07-28 per dwg revb (ecn 08-506) DD verified by:EC IPP Rev C
11.07.14 now in-house EC verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M304S16GA  304/316 Sheet .063 | | Purchased | | No | | | sf | 222.7000 | | 0.8 | 1.5 | | |
| | | | | | | | | |  | | FB1-8-4 | | |
| | | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | |
| | | | | | MAT020 | | | 22.7 | | | | | |
| | | | | | 117275 | | | 1.7 | | 10275 | | | |
| | | | | | 117653 | | | 21 | | | | | |
| | | | | | MAT021 | | | 200 | | | | | |
| | | | | | 118217 | | | 200 | | | | | |

(30)

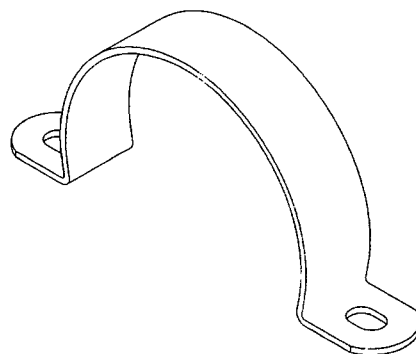
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
08-07-2011

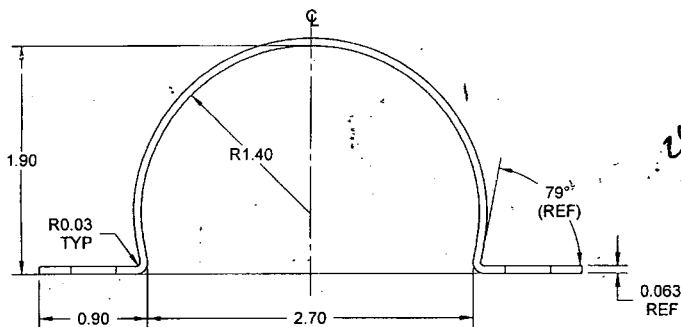
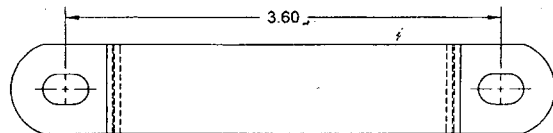
CL 11/07/13

W101.71924

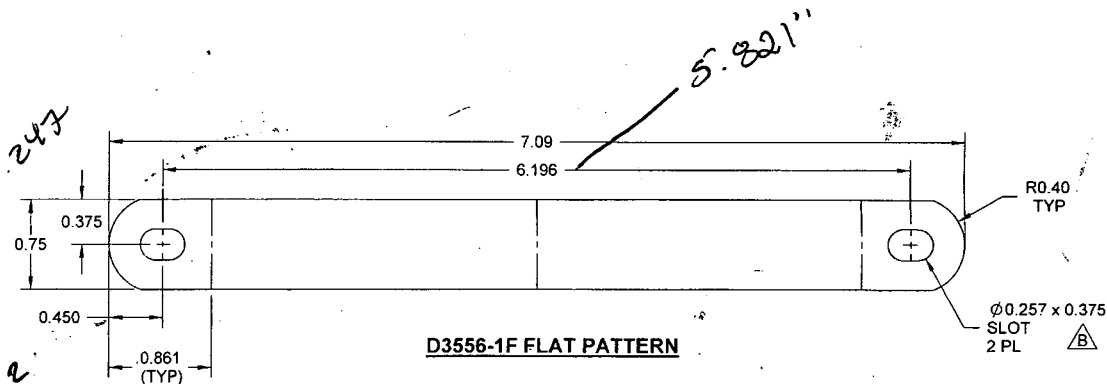
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE, PER MIL-S-5059 (REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N D3556-1 USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

| | | | | |
|------------|--|--|--------------|----------|
| B | SHEET 1 NOTE 1 MATERIAL WAS MIL-S-5019, SHT 2 ZN 61 SLOT LENGTH WAS 0.357 (REF NCR 257). DRAWING TRANSFERRED TO "B" SIZE & UPDATED TO CURRENT STANDARDS. | | AJS | 08.07.11 |
| A | NEW ISSUE | | CB | 07.02.13 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | AJS | | | |
| CHECKED | | DRAWING NO. | REV. B | |
| MFG. APPR. | | D3556 | SHEET 1 OF 2 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | CLAMP | NTS | |
| DATE | 08.07.11 | <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | | |



D3556-1 CLAMP



D3556-1F FLAT PATTERN

RELEASED
08.07.11

| | | | |
|------------|-----|--|-----------|
| DESIGN | CB | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3556 | REV. B |
| MFG. APPR. | | SHEET 2 OF 2 | |
| APPROVED | | TITLE CLAMP | SCALE NTS |
| DE APPR. | | DATE 08.07.11 | |
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